

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

Page 1

[illegible]

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and data. This can involve research, consultation with experts, or collecting data from various sources.

3. The third step is to analyze the information and data collected. This involves identifying patterns, trends, and relationships that can help in understanding the problem.

4. The fourth step is to develop a solution or answer. This involves applying the knowledge and skills gained from the previous steps to create a plan or strategy that addresses the problem.

5. The fifth step is to implement the solution. This involves putting the plan into action and monitoring the progress to ensure that the solution is effective.

6. The sixth step is to evaluate the results. This involves assessing the outcomes of the solution and determining whether they meet the requirements of the task.

7. The seventh step is to communicate the results. This involves sharing the findings and conclusions with the relevant stakeholders and providing feedback on the process.

8. The eighth step is to reflect on the process. This involves thinking about what worked well and what could be improved for future tasks.

9. The ninth step is to document the process. This involves creating a record of the steps taken and the results achieved, which can be used as a reference for future tasks.

10. The tenth step is to review the process. This involves periodically reviewing the process to ensure that it remains relevant and effective.

[illegible]

1. *Pharmaceutical industry*—The pharmaceutical industry is the largest and most profitable of the major industries in the United States. It is a highly competitive industry with a high degree of technological sophistication. The industry is characterized by a high degree of concentration, with a few large firms dominating the market. The industry is also characterized by a high degree of innovation, with new drugs being developed at a rapid pace. The industry is also characterized by a high degree of regulation, with the Food and Drug Administration (FDA) overseeing the development and marketing of new drugs. The industry is also characterized by a high degree of research and development, with a large portion of the industry's revenue being spent on research and development. The industry is also characterized by a high degree of marketing, with a large portion of the industry's revenue being spent on advertising and promotion. The industry is also characterized by a high degree of distribution, with a large portion of the industry's revenue being spent on distribution. The industry is also characterized by a high degree of competition, with a large number of firms competing for market share. The industry is also characterized by a high degree of innovation, with new drugs being developed at a rapid pace. The industry is also characterized by a high degree of regulation, with the Food and Drug Administration (FDA) overseeing the development and marketing of new drugs. The industry is also characterized by a high degree of research and development, with a large portion of the industry's revenue being spent on research and development. The industry is also characterized by a high degree of marketing, with a large portion of the industry's revenue being spent on advertising and promotion. The industry is also characterized by a high degree of distribution, with a large portion of the industry's revenue being spent on distribution. The industry is also characterized by a high degree of competition, with a large number of firms competing for market share.

\_\_\_\_\_

[illegible]

Date:

**Insp.  
Stamp**

Rev D

LA 11/10/14

Program part number and batch number. ☐ Fixturing Inspection last completed  
11/10/13 by me ☐ 1-Machine Step No 1 of Folio and visually inspect as  
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually  
inspect as per attached Dimension

B.A 11/10/14

Machine Keyway and inspect per attached dimension sheet

B.A 11/10/14

## Quality Control

Dart Aerospace Ltd

## WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74471**

Monday, October 03, 2011 9:25:10 AM



Page 2

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

SL 11-10-17



QC

Memo

0.00

(10)

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø M-L 11/10/17

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00 OVEN TEMPERATURE:

FINISH TIME: 9:30

9:30

10X Ø M-L 11/10/18

M11745

3200F

Dart Aerospace Ltd

## WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74471**

Page 3

Monday, October 03, 2011 9:25:10 AM

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 d 24 11/10/18  
COVER

170

Identify as per dwg &amp; Stock Location 51476 0.00



Packaging

Memo

0.00

Packaging

SP 11-10-18

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/10/18  
mf  
11-10-18

Dart Aerospace Ltd

# WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, October 03, 2011 9:25:14 AM

Page 1

Work Order ID: 74471

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206



Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat - in house process□EC□  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	10			

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

3  
7 and 11/10/13

Dart Aerospace Ltd

# WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	74471
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.111	0.110	0.110	0.111		
B	0.100	0.140		.111	.111	0.112	0.115		
C	1.250	1.270		1.134	1.132	1.133	1.139		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.253	0.253	0.252	0.249		
F	1.437	1.487		1.321	1.320	1.321	1.322		
G	0.210	0.230		0.222	0.222	0.222	0.223		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.5715	1.5725	1.578		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.111	0.111	0.111	0.111		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.367		
V	0.787	0.807		0.798	0.798	0.798	0.798		
W	0.540	0.560		0.550	0.552	0.552	0.552		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	0.258	0.258		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.501	0.500	0.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>one</i> / H.A
Date: 11/10/13 / 11/10/14

Audited by: <i>J</i>
Date: 11-10-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

# WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74471

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <del>74458</del>
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				Date
				5	6	7	8	
A	0.100	0.140		0.111	.112	.112	.112	
B	0.100	0.140		0.114	.112	.112	.112	
C	1.250	1.270		1.1377	1.134	1.135	1.135	
D	0.615	0.685		0.675	0.675	0.675	0.675	
E	0.240	0.260		0.251	.251	.252	.250	
F	1.437	1.467		1.322	1.320	1.320	1.320	
G	0.210	0.230		0.222	.222	.222	.222	
H	0.100	0.180		0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.565	1.585		1.577	1.572	1.574	1.574	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.111	0.111	0.111	0.111	
M	0.990	1.010		0.999	0.999	0.999	0.999	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.798	.794	.795	.795	
W	0.540	0.560		0.552	.550	.549	.547	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.920	.919	.919	.922	
AA	0.490	0.510		.501	.500	.500	.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by: <u>HA</u> / <u>cmk</u>	Audited by: <u>JL</u>
Date: <u>11/10/14</u> / <u>11/10/14</u>	Date: <u>11-10-17</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74471 <del>74358</del>
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2661-2
<b>Inspection Dwg:</b> D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

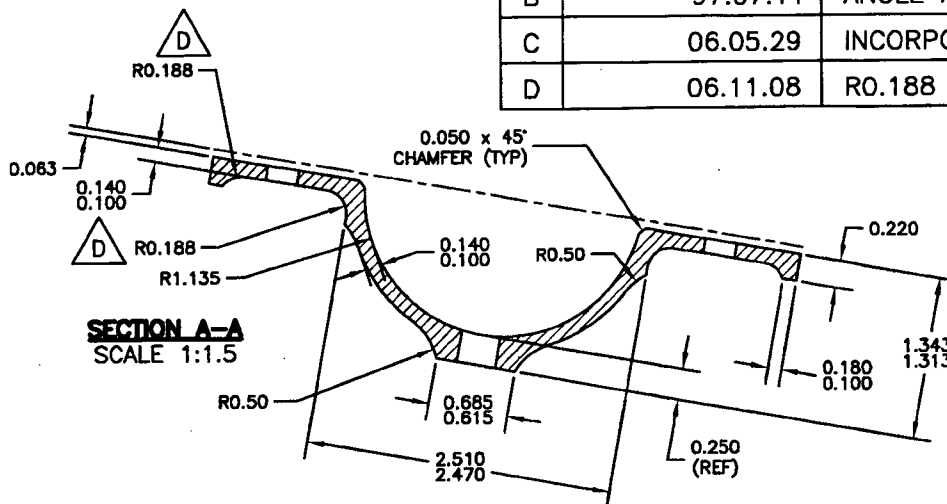
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				9	10				
A	0.100	0.140		.112	.110				
B	0.100	0.140		.114	.111				
C	<del>1.250</del>	<del>1.270</del>		1.138	1.134				
D	0.615	0.685		.675	.675				
E	0.240	0.260		.250	.250				
F	<del>1.437</del>	<del>1.467</del>		1.321	1.319				
G	0.210	0.230		.223	.220				
H	0.100	0.180		.135	.135				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.578	1.573				
K	0.235	0.240		.238	0.238				
L	0.100	0.120		.114	0.115				
M	0.990	1.010		1.000	0.999				
N	0.510	0.515		.512	0.512				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.315	0.315				
S	0.315	0.322		.317	.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.795	.792				
W	0.540	0.560		.549	.549				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.920	.919				
AA	0.490	0.510		.498	0.500				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>cmk / HA</u>	Audited by: <u>JL</u>
Date: <u>11/10/14 / 11/10/17</u>	Date: <u>11-10-17</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

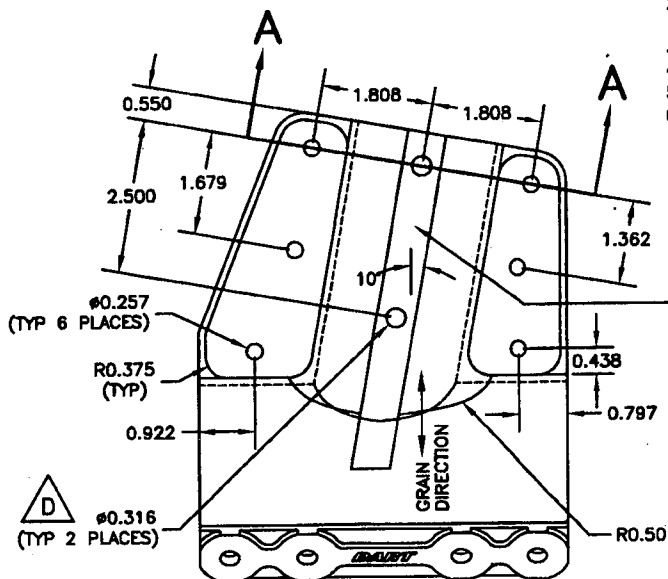
DESIGN <b>AH</b>		DRAWN BY <b>CB</b>		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>		APPROVED <b>AH</b>		DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE SCALE 1:3			
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.29		INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08		R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

**RELEASED**07-03-12  
SHOT COPY

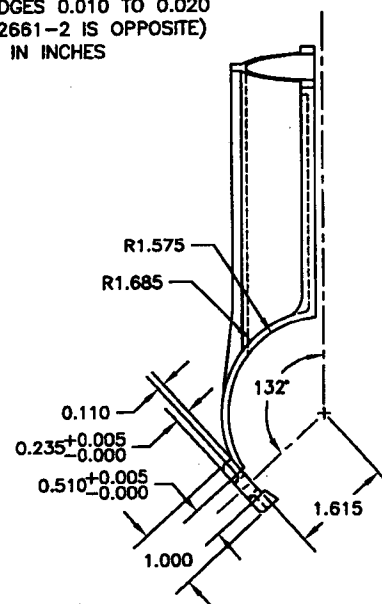
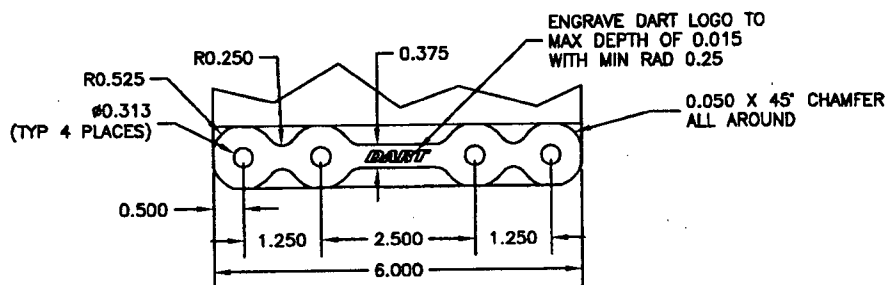
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74471 M.L.J  
11/10/03

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

**D2661-1 SADDLE OUTSIDE****Copyright © 1997 by DART AEROSPACE USA, INC.**

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: I/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries